

Date: Tuesday, 6/23/2006 8:31:25 AM
 User: Kim Johnston

Process Sheet

Split 06/05/31

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG BRACKET
 Job Number : 27188 -3
 Estimate Number : 10364
 P.O. Number : N/A Part Number : D3046041
 This Issue : 5/23/2006 S.O. No. : N/A Drawing Number : D3046 REV. A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : A
 Previous Run : 25924 Material : N/A
 Written By : SAD COMMENT Below Due Date : 6/2/2006 Qty: 16 Um: Each
 Checked & Approved By : 06.05.23
 Comment : Est: A 01.08.27 New issue SM/EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D30461 Lug Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)

LUG BRACKET

Qty	Part Number	Description	Batch
1	D3046-1	Lug Bracket	B 27175 B 27196

2.0 D30463 Lug Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)

LUG BRACKET

Pick:

Qty	Part Number	Description	Batch
1	D3046-3 (Bell P/N: 206-052-106-1)	Lug Bracket	③ B 26224 ③ B 27197

Return Authorization #

Bell original batch#

3.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

- 1- Transfer drill holes from D3046-3 into D3046-1 as per Dwg D3046
- 2- Counter sink inside holes of D3046-1 as per Dwg D3046
- 3- Deburr

SAD 06:06:04

③

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

N/A 06.05.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 5/23/2006 8:31:25 AM
User: Kim Johnston

Process Sheet

Customer: OU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 27188

Part Number: D3046041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

7.0

MS20426AD57

Rivet



Comment: Qty.: 10.0000 Each(s)/Unit Total: 160.0000 Each(s)

Rivet

Qty Part Number

Description

Batch

10

MS20426AD5-7

Rivet

~~M3676~~

M3076

M7684

SB 06/06/02 (3)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3046

SB 06/06/02

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-06-02 (3)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

06 06/06/08

(3)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

06/06/09 (3)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST/20

06/06/09 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 06/06/12

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 5/23/2006 8:31:25 AM
User: Kim Johnston

Process Sheet

Customer: CU-DARQ01 Part Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 27188

Part Number: D3046041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

③
SP 0606/12

Job Completion



U 06.06.09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

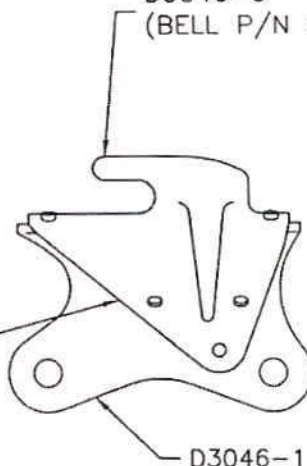
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

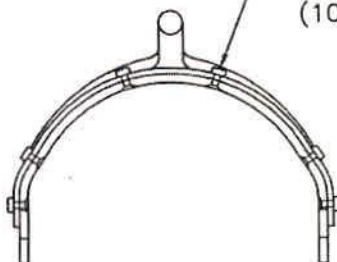
DESIGN		DRAWN BY		DART AEROSPACE LTD	
CHECKED		APPROVED		DRAWING NO.	
DATE		DATE		TITLE	
01.08.23		01.08.23		LUG BRACKET	
A		NEW ISSUE		SHEET 1 OF 2	
				SCALE	
				1:2	

D3046-3
(BELL P/N 206-052-106-1)



D3046-1

CENTER D3046-3
ON D3046-1



TRANSFER DRILL $\varnothing 0.156$ HOLES
FROM D3046-3 TO D3046-1.
C'SINK $\varnothing 0.286 \times 100$
D3046-1 INSIDE BORE.
ASSEMBLE USING MS20426AD5-7
RIVETS.
(10 PLACES)

D3046-041 LUG BRACKET ASSEMBLY

NOTES:

- 1) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.
POWDER COAT BOTH PARTS SEPARATELY BEFORE ASSEMBLY.
RE-POWDER AFTER ASSEMBLY.
- 2) REMOVE ALL PAINT/SEALANT FROM D3046-3 BEFORE POWDER COATING.

RELEASED
01.08.23

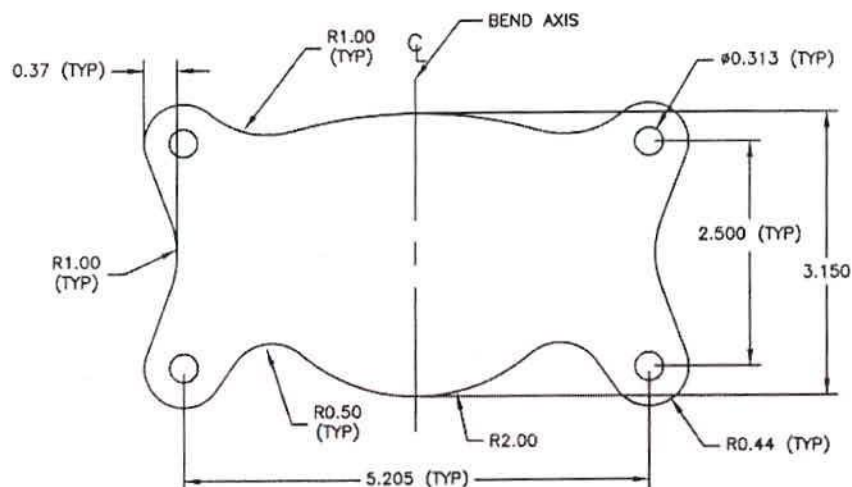
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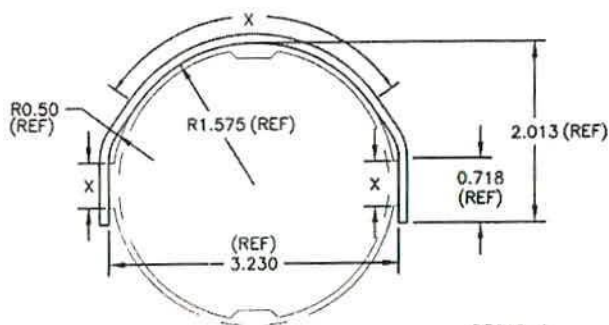
NO. 27188
WORK ORDER
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DART

DESIGN #	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3046	REV. A SHEET 2 OF 2
DATE 01.08.23		TITLE LUG BRACKET	SCALE 1:2



D3046-11 FLAT PATTERN
SYMMETRICAL ABOUT CENTRE-LINES (C)



D3046-1
(MAKE FROM D3046-11)

D3046-1 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL 0.100 THICK (12 GAUGE)
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

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01.08.27

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